

22

Date: Friday, 5/25/2007 8:22:07 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DUAL DISSABLING KIT MEDIUM BELL
Job Number : 32611	
Estimate Number : 12327	
P.O. Number :	Part Number : D412738011
This Issue : 5/25/2007 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 30693	Material :
Written By :	Due Date : 5/31/2007 Qty: 1 Um: Each
Checked & Approved By : <u>AS 07/05/28</u>	
Comment : Est Rev'D Removed Manufacturing 06-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



AS 07/05/29 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-738-011 CHG002

AS 08/03/04

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D3368041	Pedal Lock Assembly
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pedal Lock Assembly

AS 08/03/04 (X1) B 32806 7/8/04

4.0	D3393041	Battery Lock Assembly
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Battery Lock Assembly

AS 08/03/04 (X1) B 39148 7/8/04

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/03/04 (X1)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-738-011

Location:

PPP Rev:

Ensure that keys are attached to D3368-041 and D3393-041

Rev A AS 08/03/04 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:22:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL DISSABLING KIT MEDIUM BELL

Job Number: 32611

Part Number: D412738011

Job Number:



Seq. #:

Machine Or Operation:

Description :

D3368-041 Key Numbers

D3393-041 Key Numbers

C420A x1

C420A x1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D 08/03/06

Job Completion



mi 2008/3/05

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



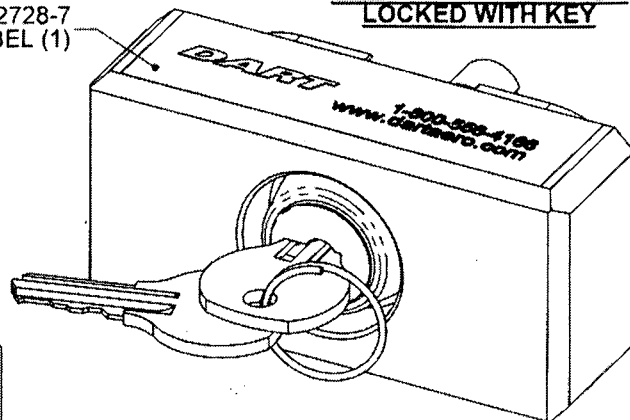
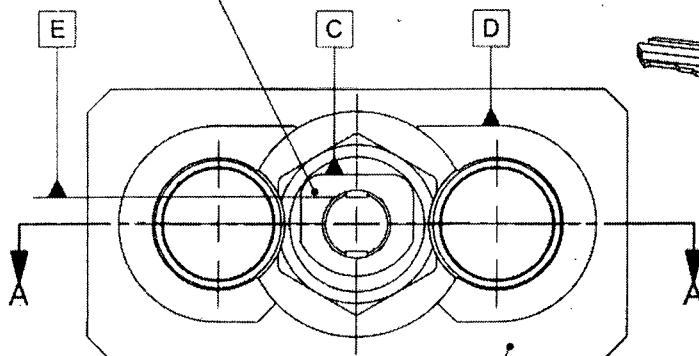
DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 43	APPROVED 43	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
43
05/03/09

D2728-7
LABEL (1)

BATTERY LOCK SHOWN
LOCKED WITH KEY

POSITION FACE C OF D3369-5
PARALLEL TO FACES D AND E
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPA

PRESS FIT
AND APPLY

D3393-3 CAM
LOCK SHAFT (1)

0.09^{+0.03}
-0.01 (2 P)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B33469

B33469

B33469 B33469

D2736 1

D2736 1